

Work Order ID 107833

107833

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Item ID: D2281

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Jack Saddle

Start Date: 10/03/13 Start Qty: 30.00

Required Date: 10/18/13 Req'd Qty: 30.00

30
30 * 35 *

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: U

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2281

Rev G

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2281 Dwg Rev: G Prog Rev: G 2-
Deburr if necessary35 0 Ae
13.10.11

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

35 0 Ae
13.10.11

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-89

B 10.11

35
can

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Item ID: D2281 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Jack Saddle
 Start Date: 10/03/13 Start Qty: 30.00 *30* Cust Item ID:
 Required Date: 10/18/13 Req'd Qty: 30.00 *30* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
140		0.00							
140	NC BRAKE								
Brake NC	Memo	0.00			DAS 30 9-89	35			SB 13/10/15
Brake NC	Form as per D2281 using D2281-T2								
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00			DAS 27 9-89	35			count
Quality Control									

13.10.15

107833

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N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 10/03/13 **Start Qty:** 30.00 ***30***

Required Date: 10/18/13 **Req'd Qty:** 30.00 ***30***

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

160

Packaging

170

Quality Control

35 13-10-15
JBC

13-10-15

pl 13-10-K

Picklist Print

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Work Order ID: 107833

Parent Item: D2281

Parent Item Name: Jack Saddle

Start Date: 10/03/13

Required Date: 10/18/13

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPP: rev B 06.07.17 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S14GA
304SS sheet .080

Purchased No

100 sf 146.8000 0.125 4

Ac 13.10.11

Location	Loc Qty	Loc Code
MAT020	146.8	
117933	4.5	
119276	14.3	
M126075	128	

119276 → 4.6

DART AEROSPACE LTD		Work Order: 107833
Description: Jack Saddle		Part Number: D2281
Inspection Dwg: D2281	Rev: G	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.477"	-		✓	OKm-01
4.114	+/-0.010	4.114"	-		✓	
2.933	+/-0.010	2.933"	-		✓	
1.535	+/-0.010	1.535"	-		✓	
0.354	+/-0.010	.354"	-		✓	
0.354	+/-0.010	.354"	-		✓	
0.604	+/-0.010	.604"	-		✓	
2.000	+/-0.010	2.000"	-		✓	
3.396	+/-0.010	3.396"	-		✓	
3.646	+/-0.010	3.646"	-		✓	
4.000	+/-0.010	4.010"	-		✓	
1.525	+/-0.010	1.525"	-		✓	
2.475	+/-0.010	2.475"	-		✓	
Ø0.323	+0.006/-0.001	.322"	-		✓	
0.080	+/-0.010	.073	-		✓	

DAS

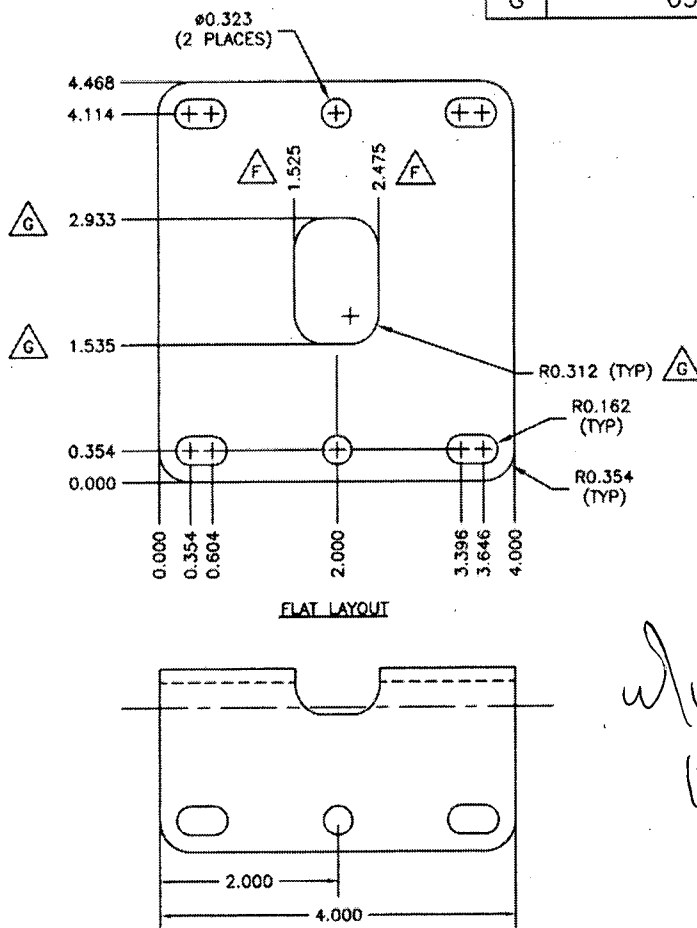
Measured by: A	Audited by: 27 9-89	Prototype Approval: N/A
Date: 13-10-11	Date: 13/10/11	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	

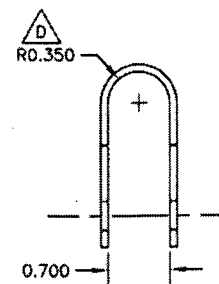


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE	SCALE 1:2	
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
[Signature]
05/08/11



w/o 107833



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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